

5093830



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D6103-003
Job Sheet 180295



Part No: D6103-003

Job Qty: 10 ea

Part Name: Round Billet, Aluminum



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/30/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs		7/30/18	0.00	0.00	Purchasing		M 18/07/19
110	Packaging	10 pcs		7/30/18	0.00	0.00	Packaging2		M 18/07/19
120	QC	10 pcs		7/30/18	0.00	0.00	QC8	QC18	38
130	Packaging	10 pcs		7/30/18	0.00	0.00	Packaging3-2		DAG 9-89
140	QC21-SA	10 Ea		7/30/18	0.00	0.00	QC21		21 JUL 23 2018

Part Op 100 - Issue P/O: 040398 a) Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Tolerance on all Descriptions: dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required
110 - Ensure material certification is attached
130 - LOCATION: MAT043

JUL 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003P	Round Alum Billet	10 pcs (1 ea)	100-Purchasing	5093830

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6103-003P	10	0	0

Part Specifications

Specifications could not be found.

Plex 7/4/18 10:07 AM dart.lavoie.chantal

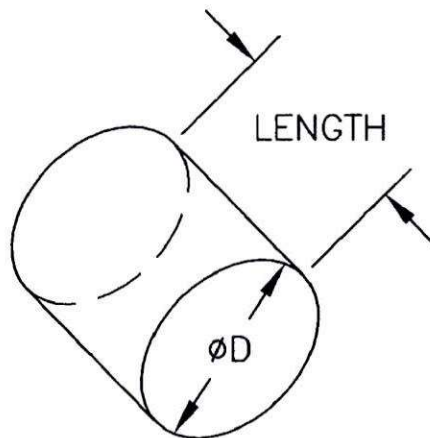
Container # 5093830



DESIGN P41	DRAWN BY P41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040398

Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040398
PO Date: 7/4/18
Due Date: 7/27/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
JUL 04 2018

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	180280	D6101-015P		Aluminum Billet As per Dwg D6101 Rev. B	Firmed	7/27/18	10 pcs	0 pcs	10 pcs	\$52.00/pcs	\$520.00
2	180281	D6101-017P		Aluminum Billet As per Dwg D6101 Rev. B	Firmed	7/27/18	30 pcs	0 pcs	30 pcs	\$29.14/pcs	\$874.20
3	180295	D6103-003P		Round Alum Billet AS PER DWG D6103 REV. B MATERIAL: 7075-T7351 AS PER QQ-A-225/9 SIZE: 3.500" X 12.500" LONG	Firmed	7/27/18	10 pcs	0 pcs	10 pcs	\$60.40/pcs	\$604.00

Grand Total: \$1,998.20

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/4/18 11:59 AM dart.baker.diane

**Castle Metals[®]**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3651224

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 18-JUL-18	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 3651224-2	

Shipment Details	Final Destination Branch - TOR
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Order No 5194014	Line No 1	Item No 8808.MO	Description 3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS-QQ-A-225/9 ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com
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Purchase Order No 40398	Part Number YOUR ITEM NUMBER: D6103-003	Ordered Qty 11.00 PCS	Invoice Qty 11.00 PCS
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Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 121944104	Mill/Source ARCONIC INC	Heat Number  MA 20180110	Mech Id	PCS 11	Width (IN)	Length (IN)	Shipped Qty(LBS) 133.3791
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26646473



We hereby certify that
Test reports are on
for credit.
Reviewed by Author

he
file
izeC

CASTLE METALS

HEAT NUMBER

MA20180110

MECHANICAL ID

ITEM CODE

8808

PO NUMBER

U55845

RECEIPT DATE

2-9-18

SUPPLIER

Arconic

SPECIFICATION

LCS

COMMENTS

APPROVED



Certified Inspection Report

02/07/18
08:55:38

Arconic Inc.
ARCONIC FORGINGS AND EXTRUSIONS
45 County Route 42, Massena, NY 13662



Customer Castle A M & Co	Customer P.O. No. 455845	Customer Part No. (8808)	Arconic Order No. MMC-C5812- -001	Govt. Contract No.
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Ship To **Castle A M & Co**
3800 Enterprise Drive
Janesville, WI 53546

We hereby certify that the material covered in this report has been inspected in accordance with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, or as previously agreed to with customer and that samples representative of the material met the composition limits and have the mechanical properties shown on the face of this sheet. Manufactured under a quality management system registered to ISO/AS9100. Melted and manufactured in the USA.

Joseph M. Vierno
Joseph M. Vierno, Quality Manager

Date Shipped 02/06/18	Weight Shipped 1,966 lbs	Product CFRB-CF ROD	Specific Length	BOL 000165522
Alloy - Temper 7075-T7351	Size 3.50000 IN	Shape DIA	Config 12 FT	QRR

Specifications:

A97075-11 Rev 15
AMS4124E
ASTMB211-12E1
Material conforms to T73 reqmts
Minimum mechanical properties to apply:
68 KSI Tensile Strength
56 KSI Yield Strength
10% Elongation
QQ-A-225/9E (Except Size)
AMS-CC-A-225/9A (Except Size)
A97075-11 Rev 16

TEST REQUIREMENTS		Test	Test	Test	Test	Test	Test	Test	Test	Test
		U.T.S.	T.Y.S.	%Elong	Cond					
Max:			67.9							
Min:		68.0	56.0	10.0	38.0					

Test Results		Test	Test	Test	Test	Test	Test	Test	Test	Test
		U.T.S.	T.Y.S.	%Elong	Cond					
Lot / Work Order	No. of Tests									
MA20180110	1									
Max:		72.8	62.2	15.0	41.4					
Min:		72.8	62.2	15.0	41.4					

TEST ABBREVIATIONS

U.T.S. Ultimate Tensile Strength KSI
Cond Conductivity % IACS

T.Y.S. Tensile Yield Strength KSI .2% offset

%Elong Elongation % in 2"

Aluminum Association Chemical Composition Limits (in Weight %)

		%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%Others	%Others	%AL			
ALLOY	MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	Rem			
7075	MIN			1.2		2.1	0.18	5.1		Each	Total				

Actual Started Chemistry

LOT/WORK ORDER		%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%OE	%OT	%AL			
	MAX	0.07	0.14	1.6	0.02	2.5	0.20	5.7	0.03	LT 0.05	LT 0.15	Rem			
	MIN	0.06	0.14	1.6	0.01	2.5	0.20	5.7	0.03						

Certified Inspection Report

02/07/18
08:55:38

Arconic Inc.
ARCONIC FORGINGS AND EXTRUSIONS
45 County Route 42, Massena, NY 13662



Customer
Castle A M & Co

Customer P.O. No.
455845

Customer Part No.
(8808)

Arconic Order No.
MMC-C5812- -001

Govt. Contract No.

NOTES:

Ingot Source: Massena

Material compliant with DFARS 252.225-7001 (Buy American Act)

Mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product.

This alloy meets the requirements of EU 2011/65/EC (RoHS) and EU 2000/53/EC for lead, mercury, cadmium and hexavalent chromium.

THESE ITEMS ARE CONTROLLED BY THE U.S. GOVERNMENT AND AUTHORIZED FOR EXPORT ONLY TO THE COUNTRY OF ULTIMATE DESTINATION FOR USE BY THE ULTIMATE CONSIGNEE OR END-USER(S) HEREIN IDENTIFIED. THEY MAY NOT BE RESOLD, TRANSFERRED, OR OTHERWISE DISPOSED OF, TO ANY OTHER COUNTRY OR TO ANY PERSON OTHER THAN THE AUTHORIZED ULTIMATE CONSIGNEE OR END-USER(S), EITHER IN THEIR ORIGINAL FORM OR AFTER BEING INCORPORATED INTO OTHER ITEMS, WITHOUT FIRST OBTAINING APPROVAL FROM THE U.S. GOVERNMENT OR AS OTHERWISE AUTHORIZED BY U.S. LAW AND REGULATIONS.

MATERIAL IS OF U.S.A. ORIGIN AND WE HEREBY CERTIFY THE PRICES TO BE TRUE AND CORRECT.

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6103-003
 DATE: 18/07/19

PO / BATCH NO.: 6040398 / 5093823

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 11
 QUANTITY INSPECTED: 11
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 3.500"
 THICKNESS RECEIVED: 3.500"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	QA-A-225/9
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	MT: MA20180110
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AM</u> DATE: <u>18/07/19</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S093830



Part: D6103-003

Job No: 180295

Serial No/Batch: S093830

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/21/18